

SC-91P

Type : Rutile

Conformances

AWS A5.36M/ ASME SFA5.36M E621T1-M21A0-G
(AWS A5.29/ ASME SFA5.29 E91T1-GM)
EN ISO 18276-A-T 55 0 Z P M21 1

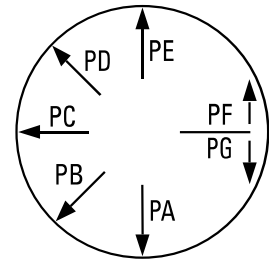
Applications

- Pipe Line
- Structural fabrication

Features

- Designed for welding with Ar + 20~25% CO₂ shielding gas
- Good bead appearance
- Good performance in all positions (Orbital welding)

Welding Position



Current

DC +

Shielding Gas

Ar + 20~25% CO₂

Diameter / Packaging

Diameter	Spool		
	5kg (11lbs)	15kg (33lbs)	20kg (44lbs)
mm (in)			
1.2 (0.045)	✓	✓	✓

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Ni	Mo
0.05	0.45	1.30	0.013	0.010	0.85	0.22

Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft-lbs)
640 (92,900)	680 (98,700)	26.0	0 (32)	80 (59)

Typical Welding Parameters

Diameter, Polarity Shielding Gas	CTWD mm (in)	Wire Feed Speed m/min (in/min)	Amp. (A)	Volt. (V)	Melt-off Rate kg/hr (lb/hr)
1.2mm (0.045 in) DC+					
80% Ar + 20% CO ₂	25 (1)	4.4~10.2 (175~400)	130~275	23~30	1.8~4.1 (4.0~9.0)

SMAW

SAW

GMAW

GTAW

FCAW

Non-FERROUS

APPENDIX